

ASAP

Date: Friday, 12/7/2007 10:20:36 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 36180	
Estimate Number : 12467	
P.O. Number : N/A	Part Number : D35121
This Issue : 12/7/2007 S.O. No. : N/A	Drawing Number : D3512 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : C
Previous Run : 31199	Material : N/A
Written By : <u>JA</u>	Due Date : 12/14/2007
Checked & Approved By : <u>JA 07.12.07</u>	Qty: 12 Um: Each
Comment : Est Rev:A New Issue 06-06-20 JLM Est Rev:B Now SS as per Rev B 06-12-15 JLM Est Rev:C Rev C dwg 07-12-06 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.2741 sf(s)/Unit Total : 3.2886 sf(s)
304 SS .063" THK (16 GA)
(M304S16GA)
Batch: 105997 IB 07-12-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3512
Dwg Rev: C IB 07-12-10
Prog Rev: C

2-Deburr if necessary IB 07-12-10

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counts
5 7/12/10 (+12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr if necessary
Form as per dwg D3512 using DT8179

SB 07/12/10

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/12/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36180

Part Number: D35121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
07/12/10 *(12)*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

Qty Description Batch

AR 20596

~~AR 7500~~ Hardcoat Rod

M106390

Ref 07/12/10 *(12x)*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-13 *(12)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m105642

FD 07/12/19 *(12)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-1

07/12/19 *(12x)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57497

07/12/19 *(12)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/20 *(12)*

Job Completion



2007/12/20
W

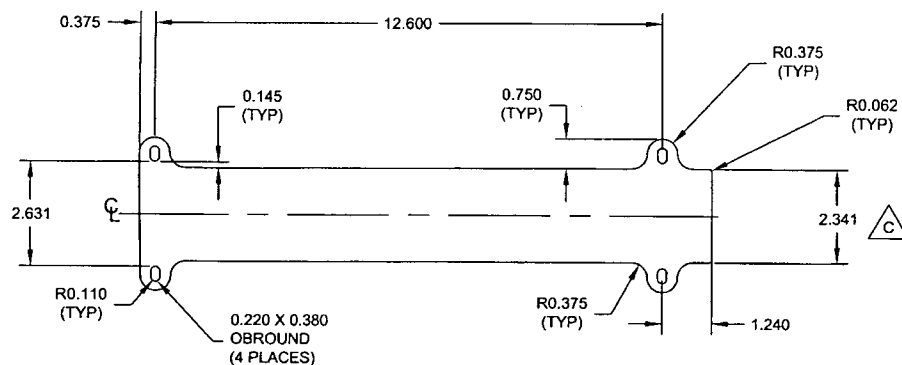
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

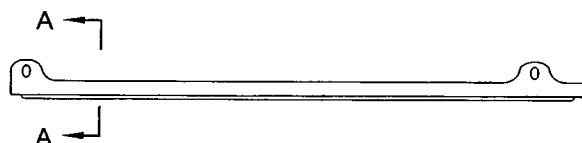
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

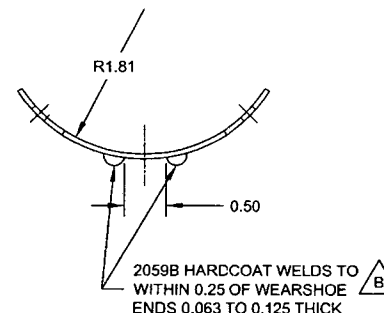
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3







RELEASED
07.11.16



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 36180

C	ENLARGE OBOURD FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO.	REV. C
DATE	07.10.05	D3512	SHEET 1 OF 1
		TITLE	SCALE
		WEARPLATE	1:
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